

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81936***81936***

Page 2

March-21-12 9:51:05 AM

Item ID: D4545-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, Inner, LH (Top Corner)

Start Date: 21/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:



SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00				2	2	1203-22	
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00				2	2	123-22	
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.00							
Quality Control									

PTO

W/O: 81936		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
1203-22	145 146	Install nutplates before paint Permanent Change	ED	1203-22	2	 C. J. J. J.	 1203-22

Part No: D 4545-045 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

81936

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 21/03/2012 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 04/04/2012 **Req'd Qty:** 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

150 ~~X~~ See

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10h35
320°F
11h05

0.00

m115128.

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

0.00

170

~~Small Fab~~

Small Fab

Memo

INSTALL NUT PLATES AS PER DWG

0.00

2 ~~Q~~ OP 12/03/23.

2 of 12-3-23

(2) FF 12-03-23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

81936

March-21-12 9:51:05 AM

N900040100

Setup Start *NS1*

Stop *NS2*

2

~

Customer:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

12/03/23 ১২২

0.00

12/3/23 sf (2)

0.00

0.00

MLJ 12/03/26
MF
12-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-21-12 9:51:08 AM

Page 1

Work Order ID: 81936

81936

Parent Item: D4545-045

D4545-045

Parent Item Name: Retainer, Inner, LH (Top Corner)

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.01.13 new issue DD verf:JLM
12.02.27 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4541-5		Manufactured	No			100	Each	2.0000	1	2			
<p>*D4541-5*</p> <p>Bracket</p>													

Location

Loc Qty

Loc Code

FG

2

78277

2

B B/23

12/03/21

D4542-5		Manufactured	No			100	Each	2.0000	1	2			
<p>*D4542-5*</p> <p>Retainer, Inner</p>													

Location

Loc Qty

Loc Code

FG

2

78281

2

B 8/263

12/03/21

MS20426AD3-4		Purchased	No			170	Each	3,914.000	12	24			
<p>*MS20426AD3-4*</p> <p>RIVET</p>													

Location

Loc Qty

Loc Code

ST316

3914

104374

1006

110398

2908

24

MS21059L3K		Purchased	No			170	Each	0.0000	6	12			
<p>*MS21059L3K*</p> <p>Nutplate</p>													

**

M112114 12/03/21

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	QTY -043	QTY -044	QTY -045	QTY -046	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
	X								D4545-041	RETAINER, LH INNER (LOWER)
		X							D4545-042	RETAINER, RH INNER (LOWER)
			X						D4545-043	RETAINER, LH INNER (SIDE)
				X					D4545-044	RETAINER, RH INNER (SIDE)
					X				D4545-045	RETAINER, LH INNER (TOP CORNER)
						X			D4545-046	RETAINER, RH INNER (TOP CORNER)
							X		D4545-047	RETAINER, LH INNER (TOP)
								X	D4545-048	RETAINER, RH INNER (TOP)
1	1								D4541-1	BRACKET
2		1							D4541-2	BRACKET
3			1	1					D4541-3	BRACKET
4					1	1			D4541-5	BRACKET
5							1	1	D4541-7	BRACKET
6	1								D4542-1	RETAINER
7		1							D4542-2	RETAINER
8			1	1					D4542-3	RETAINER
9					1	1			D4542-5	RETAINER
10							1	1	D4542-7	RETAINER
11	40	38	28	28	12	12	16	16	MS20426AD3-4	RIVET
12	19	18	14	14	6	6	8	8	MS21059L3K	NUTPLATE
13	1	1							MS21061L3K	NUTPLATE

~~80512~~ 4.6.5
8193612103121

RELEASED
2012-02-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIOR TO ASSEMBLY, POWDER COAT D4541-X & D4542-X WITH BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: -041/-042 = 0.38 lbs, -043/-044 = 0.27 lbs,
-045/-046 = 0.11 lbs, -047/-048 = 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

B	ADD FINISH (ZN A8-1)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.02.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4545	REV. B SHEET 1 OF 9
TITLE RETAINER, INNER	SCALE NTS

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Dart Aerospace Ltd

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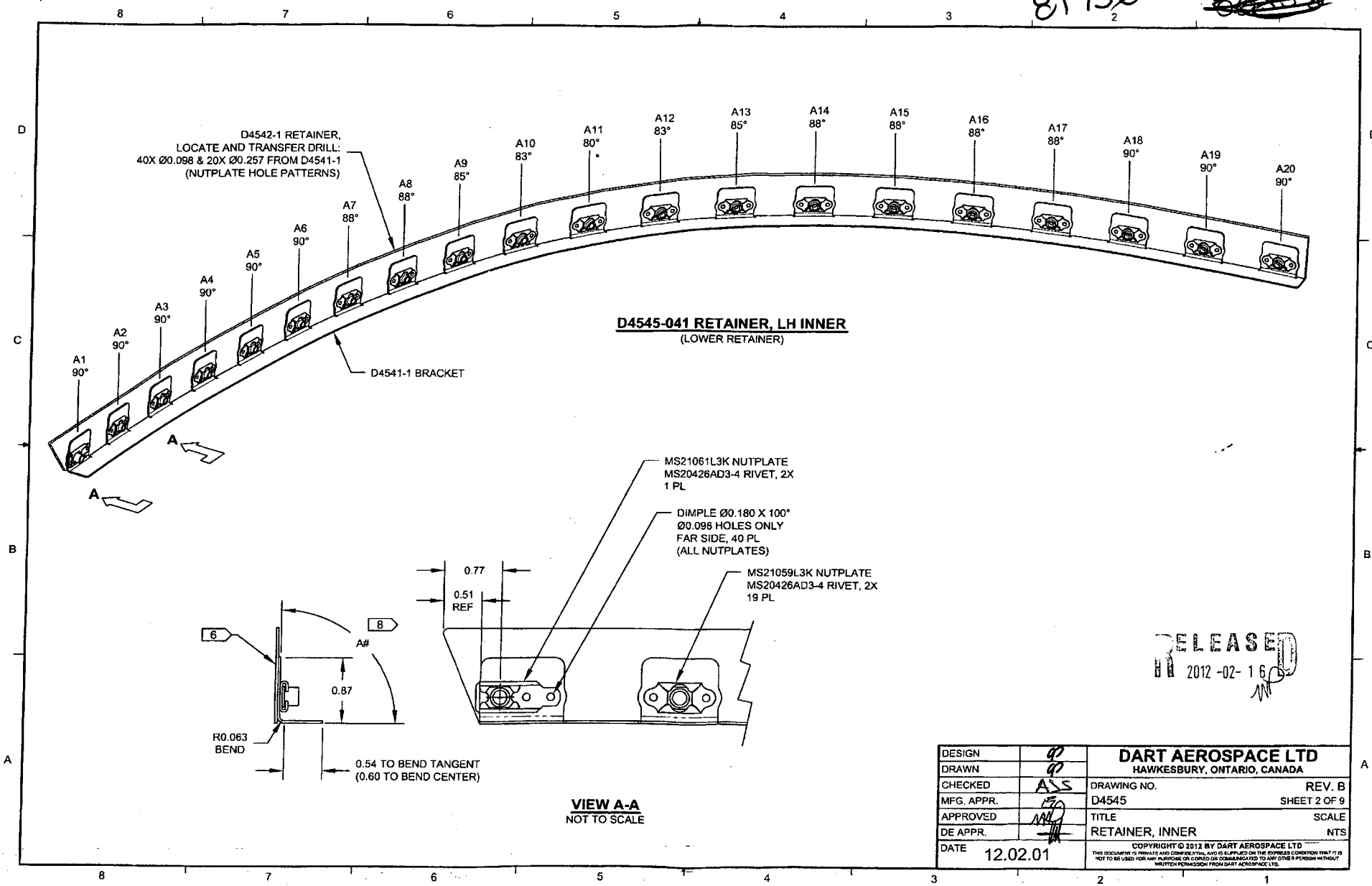
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NOTE: Date & initial all entries

81936

~~81936~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

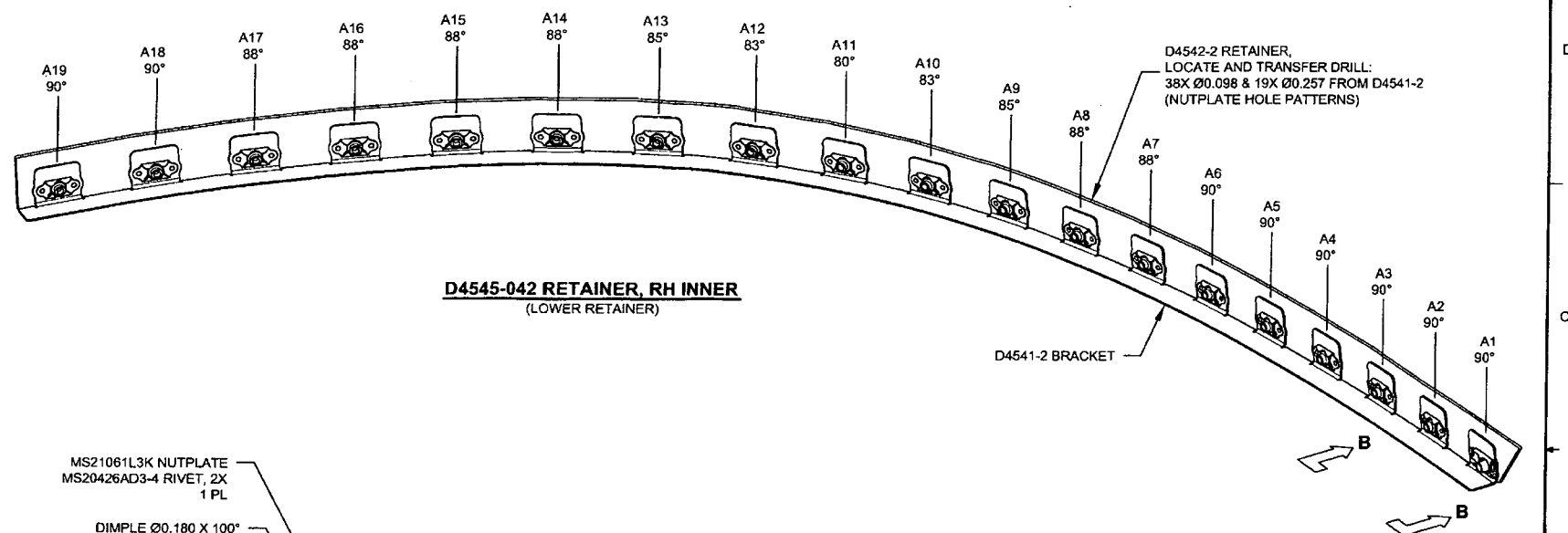
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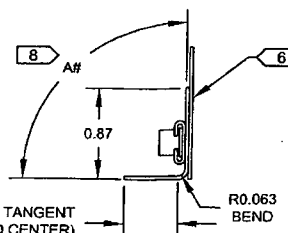
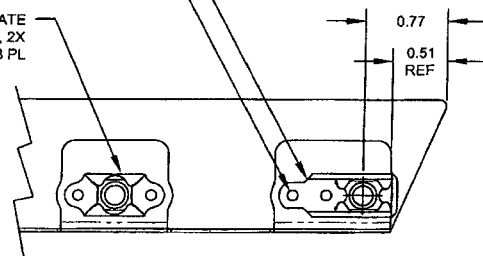
81936

~~81936~~

MS21061L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
1 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 38 PL
(ALL NUTPLATES)

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
18 PL



VIEW B-B
NOT TO SCALE

RELEASED
2012-02-16

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	90	D4545	SHEET 3 OF 9
APPROVED	90	TITLE	SCALE
DE APPR.	90	RETAINER, INNER	NTS
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NOTE: Date & initial all entries

81936

80502

D4542-3 RETAINER,
LOCATE AND TRANSFER DRILL:
28X Ø0.098 & 14X Ø0.257 FROM D4541-3

D4545-043 RETAINER, LH INNER
(SIDE RETAINER)

D4541-3 BRACKET

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
14 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 28 PL

VIEW C-C
NOT TO SCALE

0.54 TO BEND TANGENT
(0.60 TO BEND CENTER)

R0.063
BEND

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 4 OF 9
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2012-02-16

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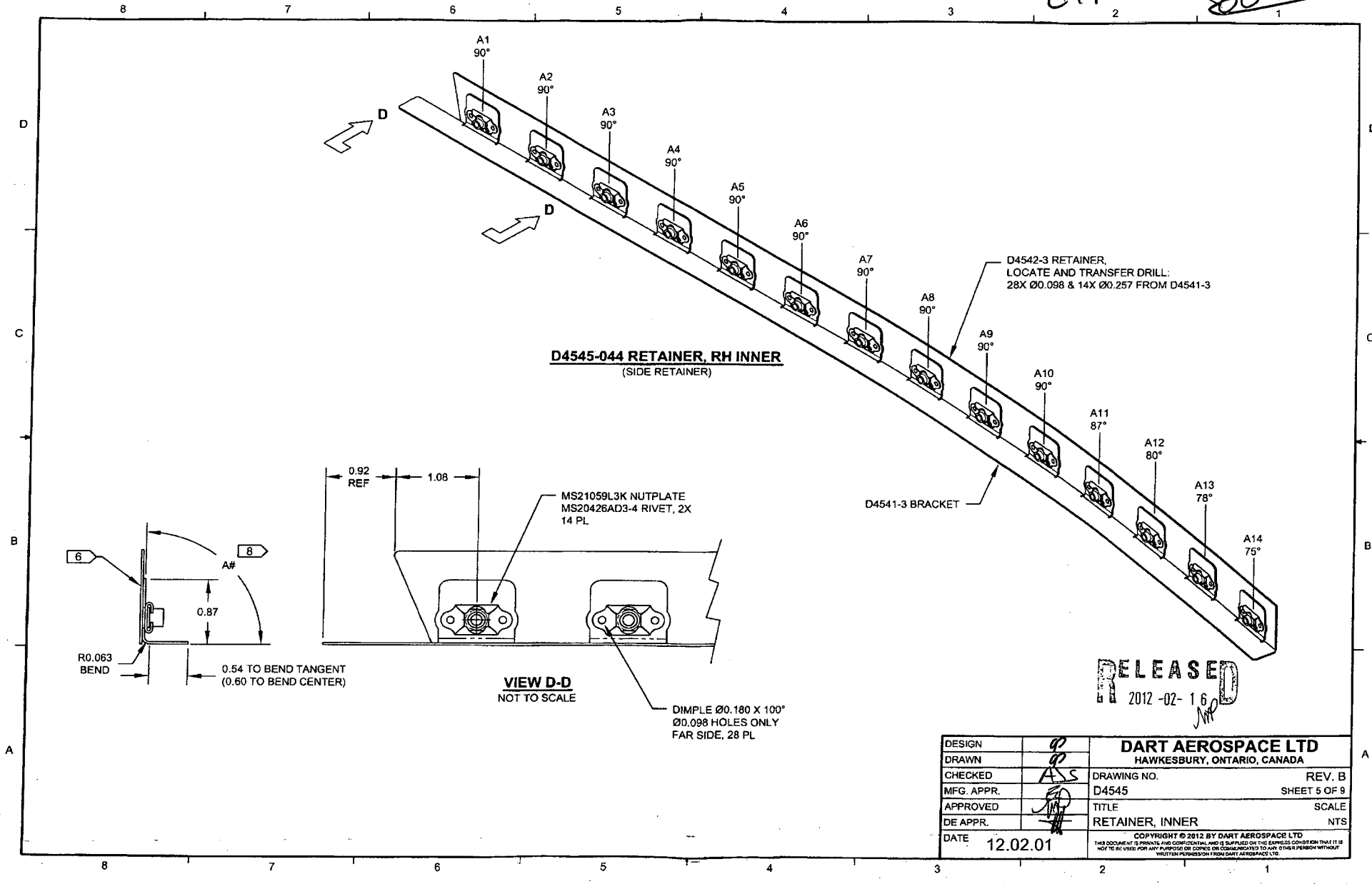
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~~80502~~



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2012-02-16

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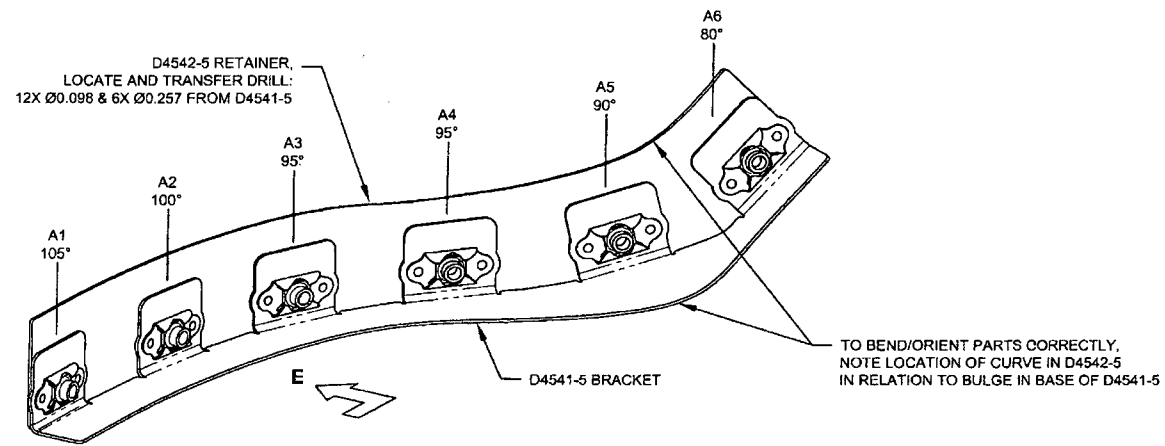
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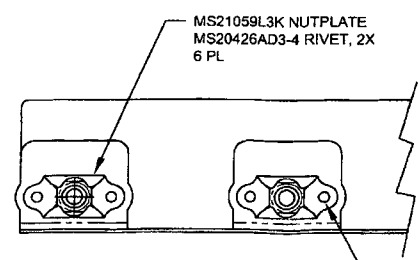
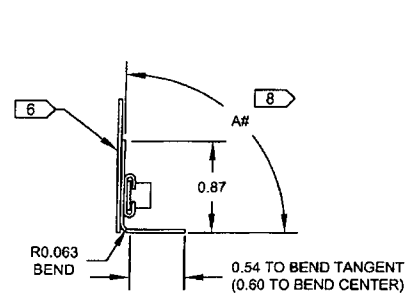
NOTE: Date & initial all entries

81936

~~81936~~



D4545-045 RETAINER, LH INNER
(TOP CORNER RETAINER)



VIEW E-E
NOT TO SCALE

RELEASED
2012-02-16

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	FO	D4545	SHEET 6 OF 9
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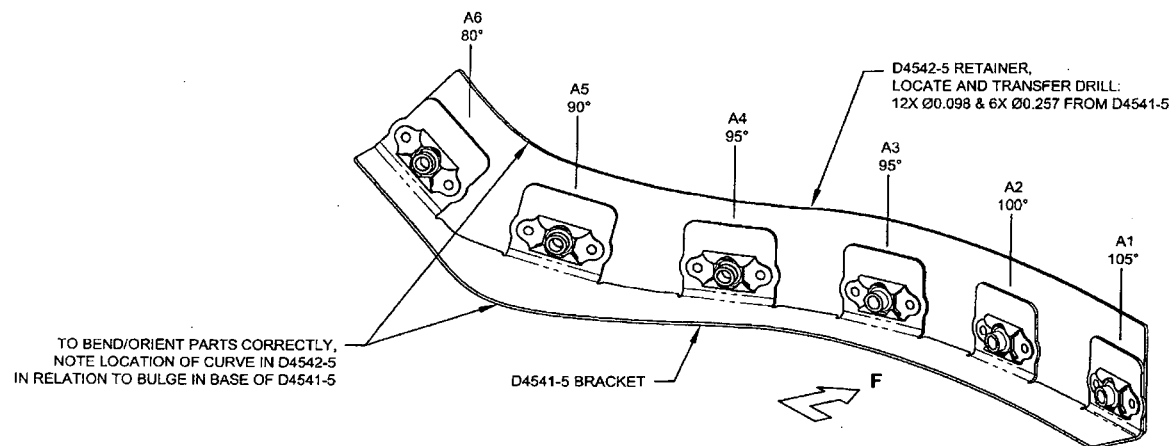
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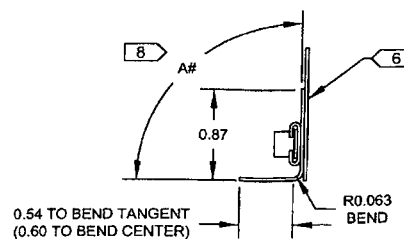
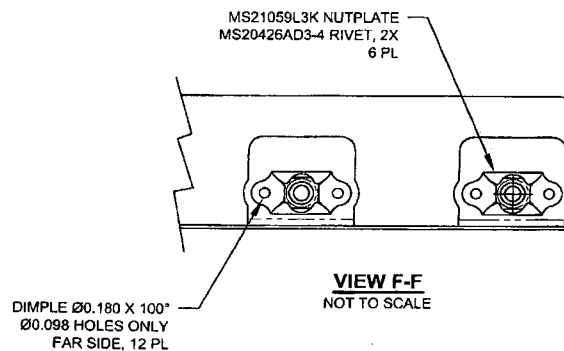
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NOTE: Date & initial all entries

81936

~~80502~~

D4545-046 RETAINER, RH INNER
(TOP CORNER RETAINER)



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2012-02-16
WFO

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CHECKED	ASS	DRAWING NO. D4545	REV. B
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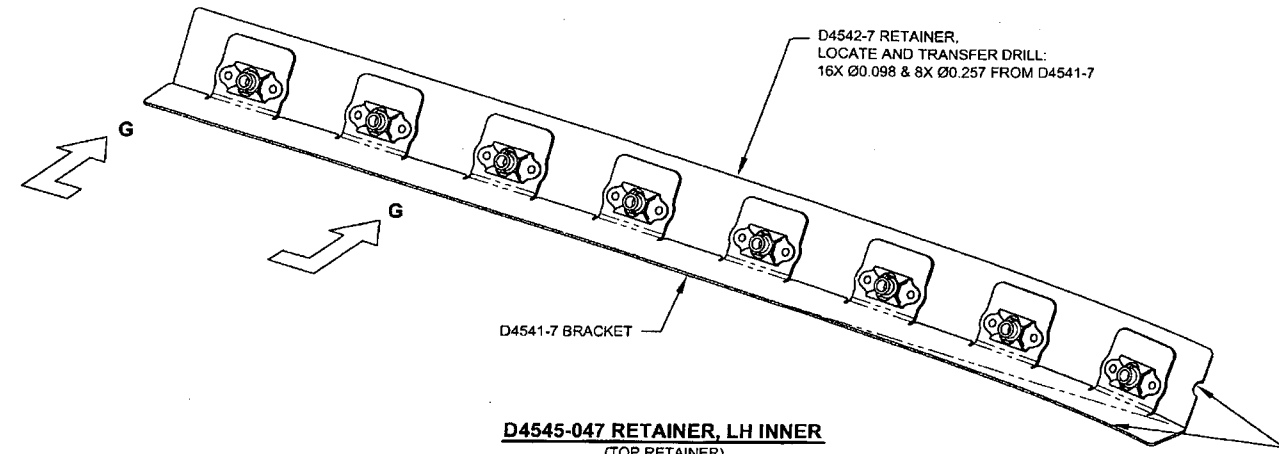
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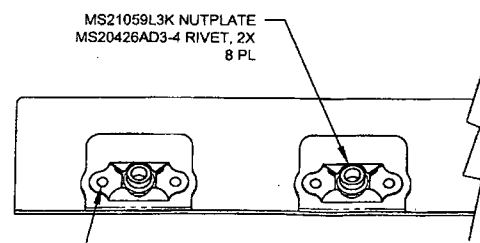
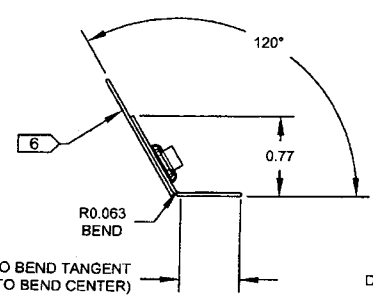
NOTE: Date & initial all entries

81936

~~80503~~



D4545-047 RETAINER, LH INNER
(TOP RETAINER)



DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

VIEW G-G
NOT TO SCALE

RELEASE
2012-02-16

DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	90		
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	130	D4545	SHEET 8 OF 9
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DE APPR.	130	RETAINER, INNER	NTS
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NOTE: Date & initial all entries

01936 ~~01936~~

TO BEND/ORIENT PARTS CORRECTLY,
NOTE LOCATION OF TOOLING MARK IN D4542-7
IN RELATION TO CURVE IN BASE OF D4541-7

D4542-7 RETAINER,
LOCATE AND TRANSFER DRILL:
16X Ø0.098 & 8X Ø0.257 FROM D4541-7

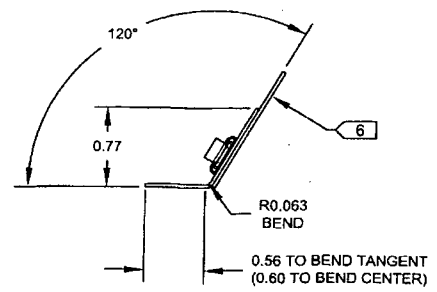
D4541-7 BRACKET

D4545-048 RETAINER, RH INNER
(TOP RETAINER)

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
8 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

VIEW H-H
NOT TO SCALE



RELEASE
2012-02-16

DESIGN	00	DART AEROSPACE LTD	
DRAWN	00	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	MD	D4545	SHEET 9 OF 9
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	RETAINER, INNER	NTS
DATE	12.02.01	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries